

Date: Tuesday, 06/01/2009 10:04:33 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HI-STEP LEG ASSEMBLY		
Job Number	: 44395					
Estimate Number	: 10385					
P.O. Number	:			Part Number	: D3065041	
This Issue	: 06/01/2009		S.O. No. :	Drawing Number	: D3065 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	Drawing Revision	: B	
Previous Run	: 43858			Material	:	
Written By	:			Due Date	: 10/02/2009	
Checked & Approved By	: <u>JWD 09.01.01</u>			Qty:	40	Um: Each
Comment	: Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	Barcode	Comments
1.0	44395A	STEP SPACER		<u>Comment: Sub-Component STEP SPACER</u> 1 x D3065-1 Batch <u>B41445</u> <u>9x</u> <u>B43858</u> <u>31x</u> <u>Sp09/02/24</u>
2.0	44395B	STEP SPACER		<u>Comment: Sub-Component STEP SPACER</u> 1 x D3065-3 Batch <u>B43858B</u> <u>37x</u> <u>B45395</u> <u>6</u> <u>3x</u> <u>Sp09/02/24</u>
3.0	44395C	STEP LEG		<u>Comment: Sub-Component STEP LEG</u> 2 x D3065-5 Batch <u>B42344</u> <u>22x</u> <u>B44395C</u> <u>58x</u> <u>Sp09/02/24</u>
4.0	44395D	STEP SPACER		<u>Comment: Sub-Component STEP SPACER</u> 1 x D3065-7 Batch <u>B41445D</u> <u>25x</u> <u>B43858</u> <u>15x</u> <u>Sp09/02/24</u>
5.0	MS20470AD44	Rivet, Universal Head		<u>Comment: Qty.: 30.0000 Each(s)/Unit Total : 1200.0000 Each(s)</u> Rivet, Universal Head Pick: Qty Part Number Description Batch 30 MS20470AD4-4 Rivet <u>1110427</u> <u>Sp09/02/24</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/01/2009 10:04:33 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 44395

Part Number: D3065041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

Sp09/02/24 40

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sp09/02/25 40

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

SAD 09-02-26 40

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/26 40

Job Completion



MF  
09-02-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

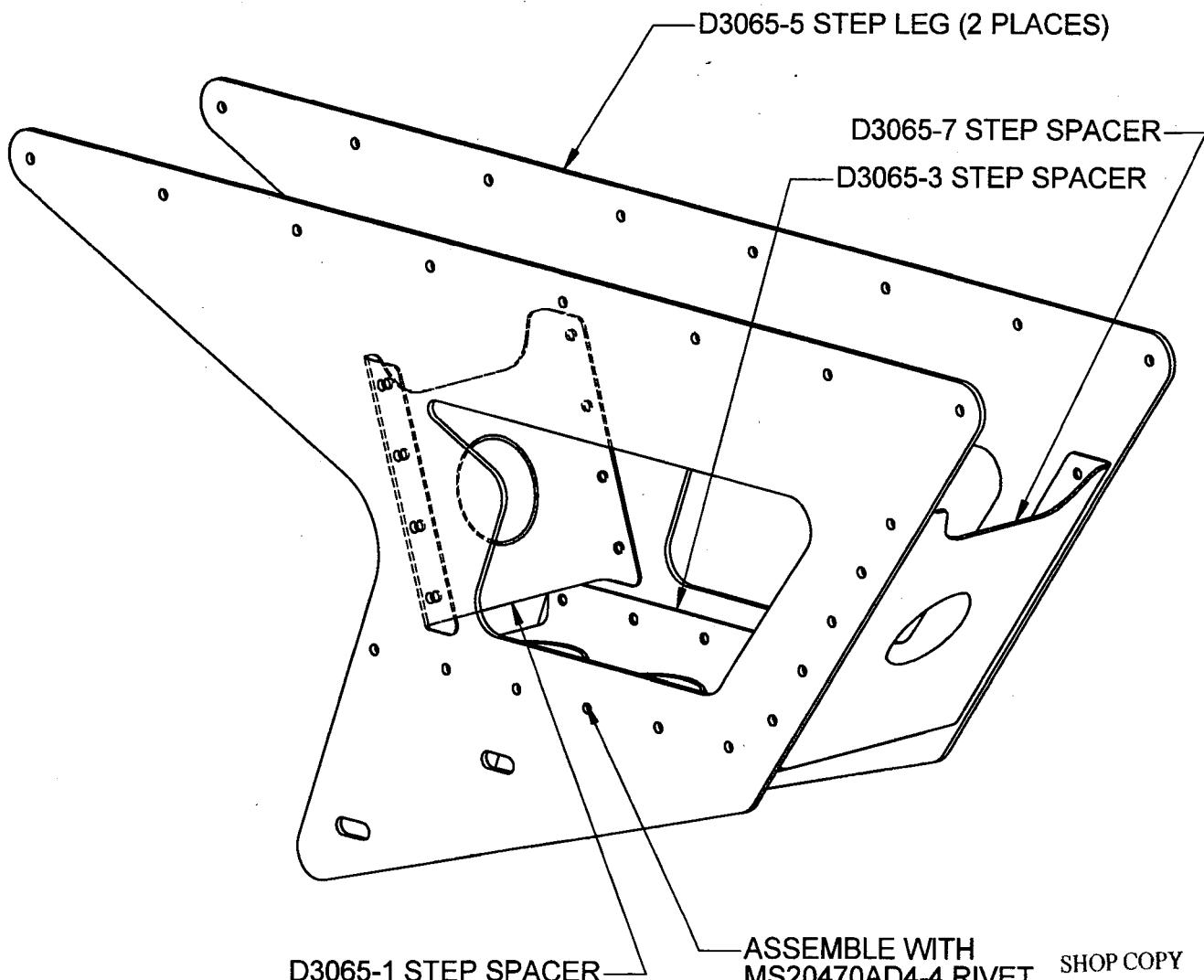
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B	SHEET 1 OF 5
DATE <b>06.05.23</b>	TITLE <b>STEP LEG ASSEMBLY</b>			SCALE 1:2
A	NEW ISSUE			
B	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5			

**RELEASED***06.06.20 [Signature]*

## D3065-041 STEP LEG ASSEMBLY

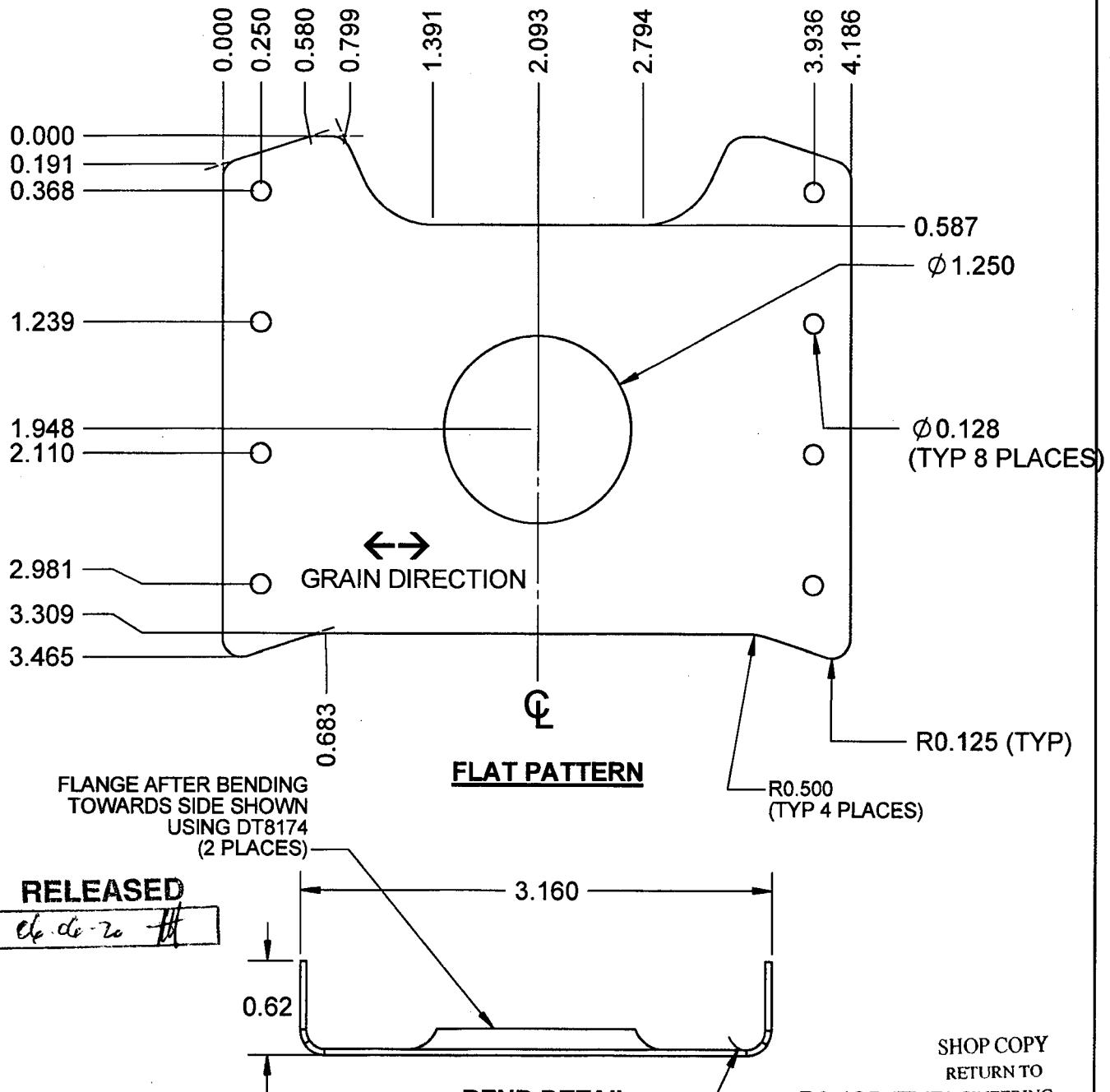
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CHECKED <i>PH</i>	APPROVED <i>M</i>	DRAWING NO. D3065
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	REV. B SHEET 2 OF 5 SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

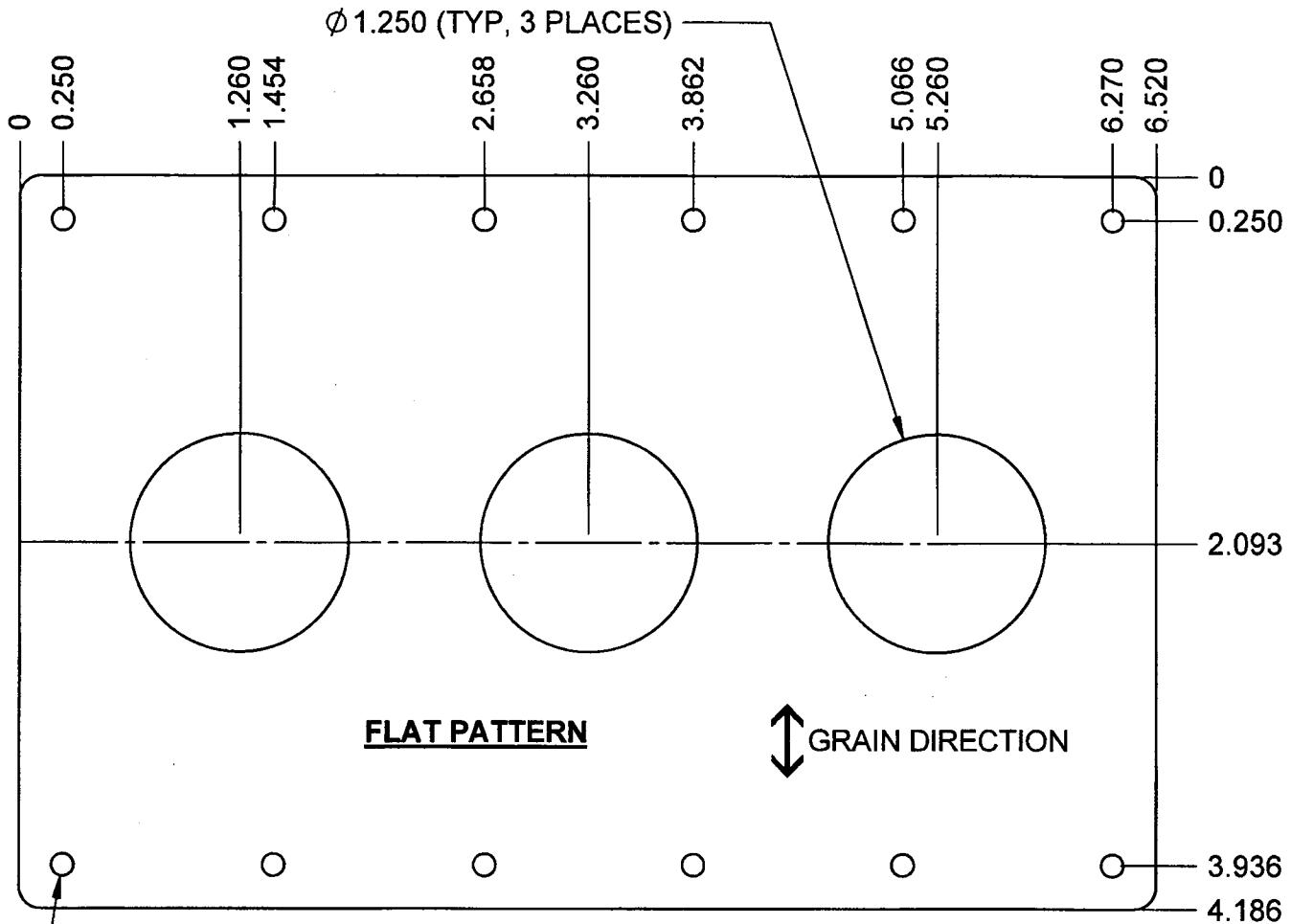
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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. <b>D3065</b>
DATE 06.05.23		REV. B SHEET 3 OF 5 TITLE <b>STEP LEG ASSEMBLY</b> SCALE 1:1

**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

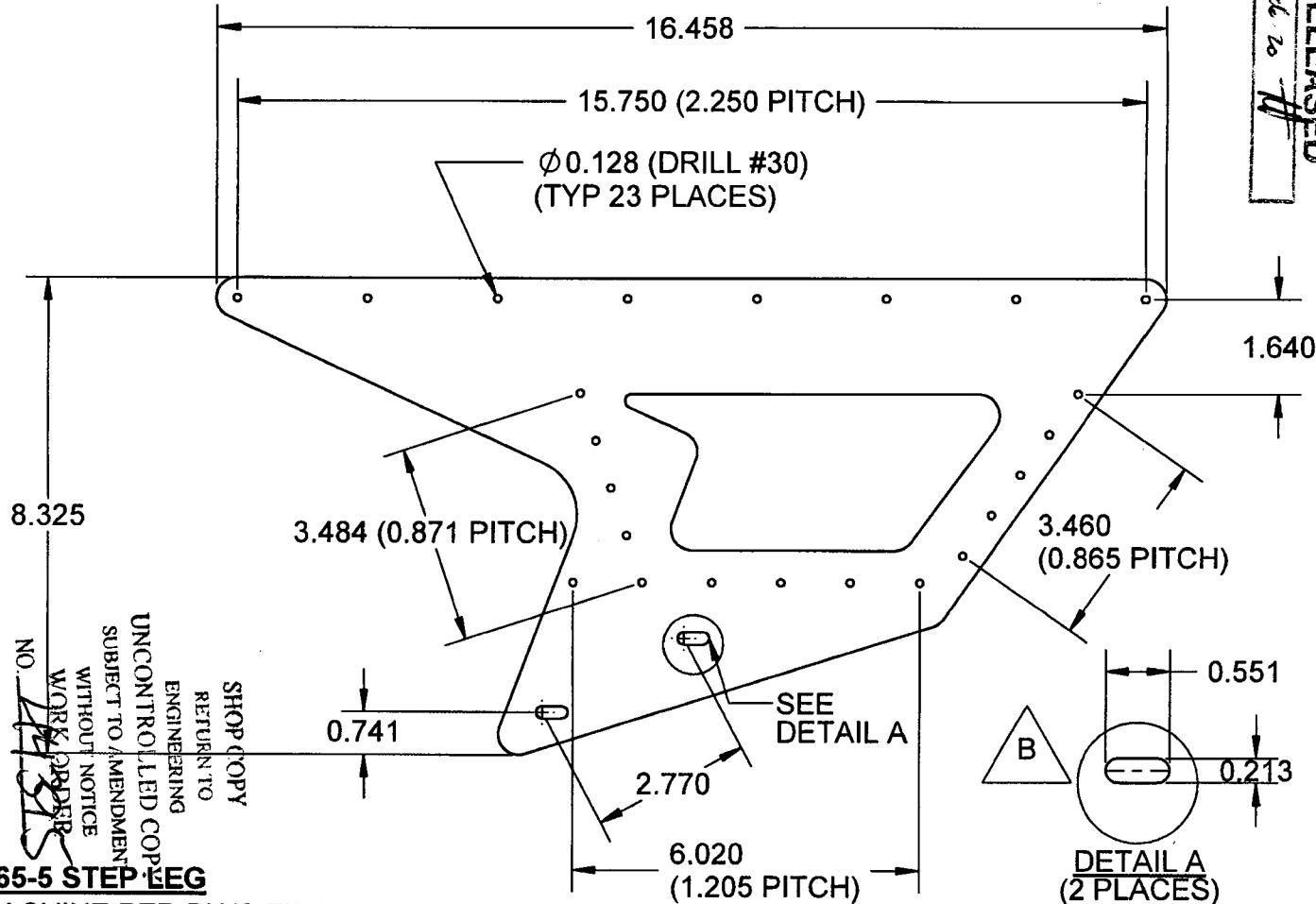
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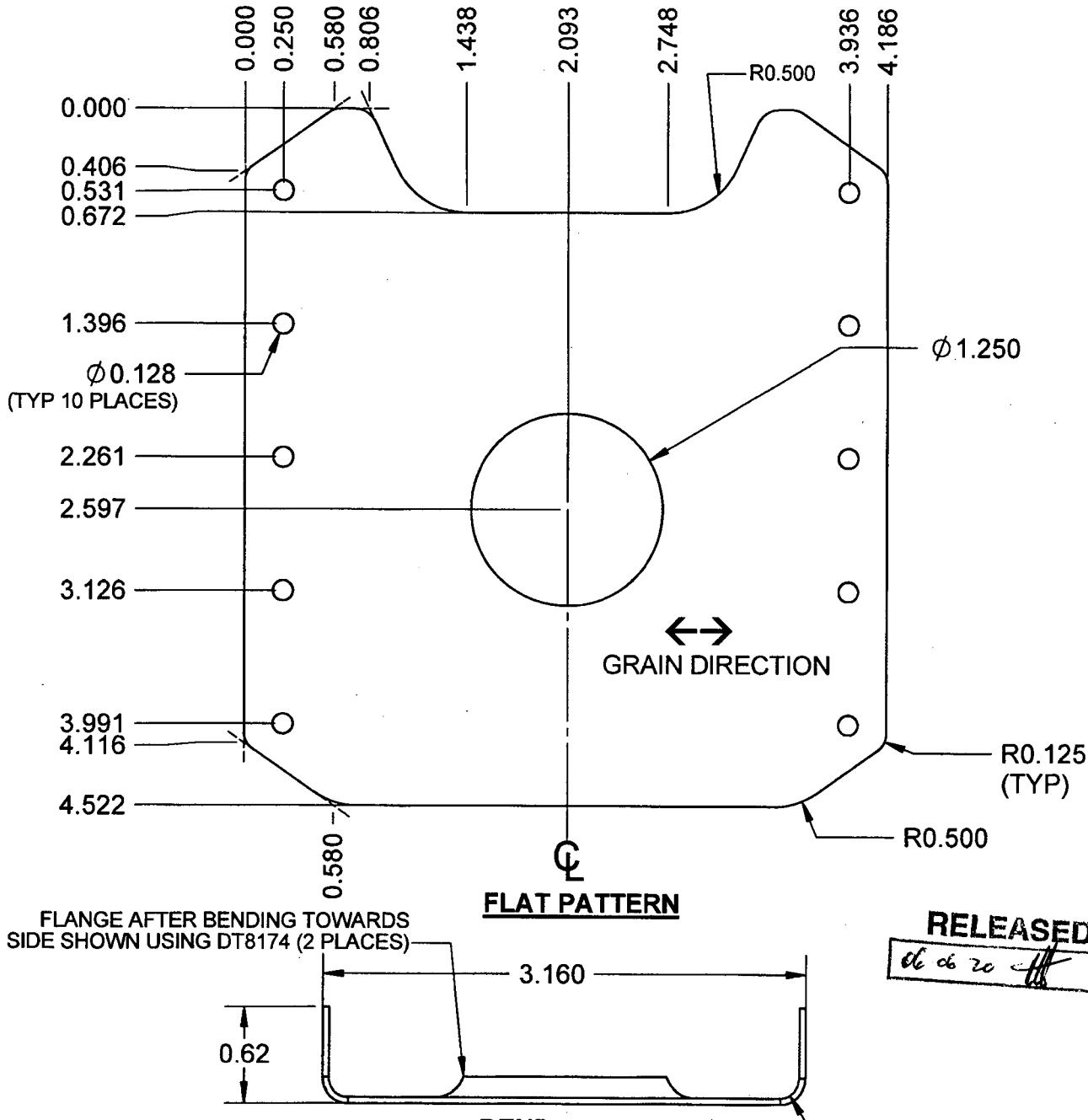
DESIGN <i>10</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>P.H.</i>	APPROVED <i>J.H.</i>	DRAWING NO. <i>D3065</i>
DATE <i>06.05.23</i>	TITLE <i>STEP LEG ASSEMBLY</i>	REV. B SHEET 4 OF 5 SCALE <i>1:3</i>



- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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